QC8- Inspect parts - second check

Quality Control

120

Quality Control

120

Memo

											DQA	:Date	e:	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	/IANCE / UP	DATE				
											QA Closed	: Date	e:	
Work Ord	or.					DISPOSITION				AGAINST DE	EPARTMENT/PROCESS			
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		=	Quality Other
Root					Descri	ption of work order update		nitial	Δα	tion	Sign &			
Cause		Date	Step	Qty	i '	or Non-conformance	l	ief Eng		ription	Date	Verification		QC Inspector
Doc/Data	П													
Equip/Tooling	Н													
Operator	П	i												
Material							ļ							
Setup	П													
Other										*			İ	
Process														
Supplier							ĺ						İ	
Training													Ì	
Unapproved			<u> </u>											
						F/	AUL	T CATE	GORY					
Landi	ng C	Gear				General		1		_	7	_	_	
	\vdash	Bending				Bend	<u></u>	Grain		_	Ovalized	1		essure/Forced
	Centre Not Concentric to O/S			o/s	BOM/Route	L_	Hardwa			-∤ '	er tolerance		emperature/Cure	
	\vdash	Cracks				Broken/Damaged	L	- 1	on Incomplete	<u> </u>	Part Incorr	⊢		eld
	_	Crushed/	Crimped.		_	Burrs		4	ions Incomplete/	'Unclear	Part Lost/i	- L	w	rong Stock Pulled
	Ш	Cuffs				Contamination	\perp	Mainte	nance	ļ	Part Move			
		Heat Trea	it			Countersink	sink Mislabeled		led		Positioned Wrong			
i	Inspection Strip in Tube		Cut Too Short	Microad				Powerlos	s/Surge	lot	ther			

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Packaging

Packaging

97264

February-14-13 1:28:26 PM Item ID: D2935 Accept *N900040100* Setup Start *NS1* **Revision ID:** Item Name: Saddle Spacer **Start Date: Start Oty: 24.00** *24* 2/14/13 Cust Item ID: Required Date: 2/22/13 Req'd Qty: 24.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Number Stamp Code Qty Qty 130 Chemical Conversion Coat per QSI005 4.1 0.00 *130* HandFinish 0.00 Memo Hand Finishing 140 QC3- Inspect Part Finish QC Memo Quality Control Identify as per dwg & Stock Location: \$\,\) 0.00 150 *150*

0.00

Memo

NCR: \	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
												QA Closed:	Da	te:		
Work Orde	ar.					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part N	Part No				Scrap Machining Small Use-as-is Thermoforming Finis			Crosstube Small Fab Finishing Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other			
Root					Descri	ption of work order update	1	nitial	Act	ion		Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription		Date	Verificatio	n	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												·				
						F	AUL	T CATE	GORY							
Landi	ng (Sear				General		1		-	,	1			1	
		Bending				Bend		Grain			$\overline{}$	Ovalized		<u> </u>	Pressure/Forced	
	_	Centre No	ot Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		Ļ.	-	Over/Under		_	Temperature/Cure	
	Cracks				Broken/Damaged		4 '	on Incomplete	-	_	Part Incorre		┡	Weld		
	_	Crushed/0	Crimped.		<u> </u>	Burrs	<u></u>	1	ions Incomplete/I	Unclear	_	Part Lost/M	issing	L_	Wrong Stock Pulled	
	\vdash	Cuffs				Contamination	<u></u>	Mainte		<u> </u>		Part Moved				
	-	Heat Trea				Countersink	<u></u>	Mislabeled		Positioned Wrong		7				
Inspection Strip in Tube			Cut Too Short Misread					Power Loss/	'Surge	L	Other					

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

97264

Page 3

February-14-13 1:28:26 PM

Required Date: 2/22/13

Item ID:

D2935

2/14/13

Accept

N900040100

Setup Start

Revision ID:

Item Name: Start Date:

Saddle Spacer

Start Qty: 24.00

24

Cust Item ID:

Customer:

Reference:

Approvals:

OC:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Run Start

Stop

Sequence ID/ Work Center ID Operation Description

Reg'd Oty: 24.00

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** Tool ID

Tool# Plan Code

Accept Qty

Reject

160

160

Quality Control

Memo

0.00

0.00

Qty

Reject

Number Stamp

MF 13-3-21

DQA:	E	Date:	

NCR:	Yes	/	No	

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	•	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS		
Part No	0.				Rework Scrap Use-as-is Work Order Update	Scrap Machining Sma Use-as-is Thermoforming Fini			ab Prod. Eng. Coor. Quality ng Rec/Store/Packaging Other			
Root				Descr	iption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Ooc/Data Equip/Tooling Operator Material Setup Other												
Supplier	-					:						
Training						}						
Unapproved												
<u>.</u>	-				F	AULT CATE	GORY					
Landin	g Gear				Genera!				_			
-	Bending Centre N Cracks		ntric to (o/s	Bend BOM/Route Broken/Damaged	-	ion Incomplete		Ovalized Over/Under Part Incorre	ct	Pressure/Forced Temperature/Cure Weld	
	Crushed/Crimped Cuffs		Burrs Contamination	Mainte		/Unclear	Part Lost/M Part Moved		Wrong Stock Pulled			
	Heat Trea		Tubo	-	Countersink Cut Too Short	Mislabe		-	Positioned \ Power Loss/		Other	
-	Inspection Ripples in	•	rube		Drill Holes	Offset	u	<u>L</u>	Trower ross	ouige [Torrier	
}	Torque V		:vtrucio:	,	Drawing	⊢	Calibration					
-				' ⊢	Finish	├ ─	Sequence					
F			Folio		Outside Dimensions				***************************************			

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

February-14-13 10:55:13 AM

Work Order ID:

97264

Parent Item:

Comments:

D2935

Parent Item Name:

Saddle Spacer

IPP A00.06.06New IssueEC

IPP Rev:B Now 6061-T6 06-06-23 JLM

Start Date: 2/14/13

Required Date: 2/22/13

Page 1

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	393.7686	0.0507	1-2808416	1.5		Jm13:3-
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT021		393.768632							
				1172	285	0.248632							
				1191	766	39.82							
				1200	096	168.8							
				1232	279	40.9							
				124:	572	144			1:24	572			

											DQA:	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C	O	VFORM	ANCE / UPD	ATE	·		_	· · · · · · · · · · · · · · · · · · ·
											QA Closed:	Dat	e:	
Work Orde	or:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOIR OIG	٠					Rework		Skid-tube	Crosstube	Water Jet			Engineering	
Part N	No. ِ					Scrap			Machining	Small Fab Finishing	Prod. Eng. Coor. Rec/Store/Packaging			Quality
NCR I	NCR No.					Work Order Update	<u> </u>			Composite	31			
Root Des						ption of work order update		nitial	Acti	on	Sign &			
Cause		Date	Step	Qty	Ċ	or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	1	QC Inspector
Doc/Data														
Equip/Tooling														
Operator														
Material					-									
Setup					,									
Other														
Process													١	
Supplier														
Training											İ			
Unapproved											<u></u>			
						F	AUL	T CATE	GORY					
Landi	ng C	Gear				General		-			•	r		
		Bending				Bend	L	Grain			Ovalized		-	Pressure/Forced
	L	Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Ш	Temperature/Cure
		Cracks			ļ	Broken/Damaged		Inspecti	on Incomplete	<u> </u>	Part Incorre	ct	-	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved			
		Heat Trea	at			Countersink		Mislabe	eled		Positioned \	Wrong .	r,	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Loss,	'Surge		Other
	Ripples in Bend		Drill Holes		Offset									

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

DART AEROSPACE LTD	Work Order:	97764
Description: Saddle Spacer	Part Number:	D2935
Inspection Dwg: D2935 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

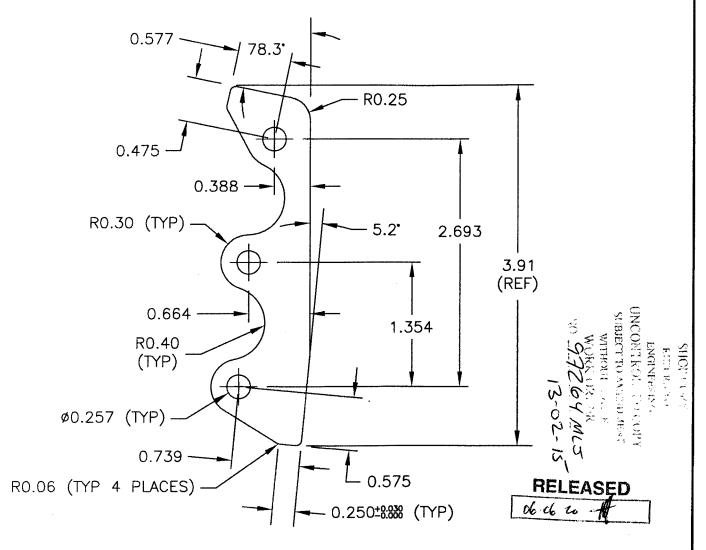
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0,258			\/	
3.91	+/-0.030	3.922"	_		V	
1.354	+/-0.010	1.357"	-		V	
2.693	+/-0.010	2.695"	_		V	
0.250	+/-0.010	0.259"	•		V	
R0.25	+/-0.030	0.25"	_		RG	
			<u> </u>			
					;	

Measured by:	Jm	Audited by: OAS	Prototype Approval:	N/A
Date:	(3-3-17	Date: 3-95 13/03/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.06.05	New Issue	KJ/JLM	1
В	06.06.23	Dwg Rev. changed	KJ/JLM	
			: 17	



DESIG	N . T	DRAWN BY	DART AEROSPACE PORT HADLOCK, WA	
CHEC		APPROVED	DRAWING NO.	REV. B
	PH	- At	D2935	SHEET 1 OF 1
DATE			TITLE	SCALE
06.0	5.29		SADDLE SPACER	1:1
Α		99.11.02	NEW ISSUE	
В		06.05.29	ADD 6061-T6 MATERIAL	



NOTES:

6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK 1) MATERIAL: (REF DART SPEC M6061T6S.080)

ÓR

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK

(REF DART SPEC M5052H32S.080)

- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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